

Work Order ID 70380

Monday, June 06, 2011 9:26:35 AM



Page 1

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 11-06-06 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Debur if necessary

B11-G-7



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-G-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5 u66608



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3535-21

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Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(8)			
Brake NC	Memo Form berid & joggle as per Dwg D3535 using DT8261 & DT8326	0.00							
				JB 11/06/08					
140 QC	QC5- Inspect part completeness to step on W/O	0.00				(49)			
Quality Control	Memo	0.00		S 11/06/08					
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo	0.00							
	START TIME: 8:30								
	FINISH TIME: 9:20								

8X M-11/06/09

115128

3200

9:20

W/O:		WORK ORDER CHANGES					
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Monday, June 06, 2011 9:26:35 AM



Page 3

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 0 11-6-9

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

8x 0 M-F 11/06/09

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/09

MF 11-06-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 06, 2011 9:26:31 AM

Page 1

Work Order ID: 70380



Parent Item: D3535-21



Parent Item Name: Wearshoe



Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	266.3814	0.8925	5.636842	7.2		
											MB11-6-7		

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

266.3814

116623

0.2

117550

10.1814

117933

256

117933

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 70380
Description: Wearshoe		Part Number: D3535-21
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	X		V 180Z	
2.000	+/-0.010	2.000	✓		V	
2.000	+/-0.010	2.000	✓		V	
1.885	+/-0.010	1.890	X		V	
0.300	+/-0.010	.302	✓		V	
0.300	+/-0.010	.307	+		V	
5.450	+/-0.010	5.450	✓		T 1301	
10.900	+/-0.010	10.900	✓		T	
16.350	+/-0.010	16.350	✓		T	
21.800	+/-0.010	21.800	X		T	
27.250	+/-0.010	27.250	X		T	
32.700	+/-0.010	32.700	✓		T	
6.00	+/-0.030	6.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	X		T	
24.00	+/-0.030	24.00	X		T	
0.040	+/-0.010	.036	X	V	V	

Measured by: B	Audited by: J	Prototype Approval: N/A
Date: 11-6-7	Date: 11/6/68	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.2.02	New Issue	KJ	

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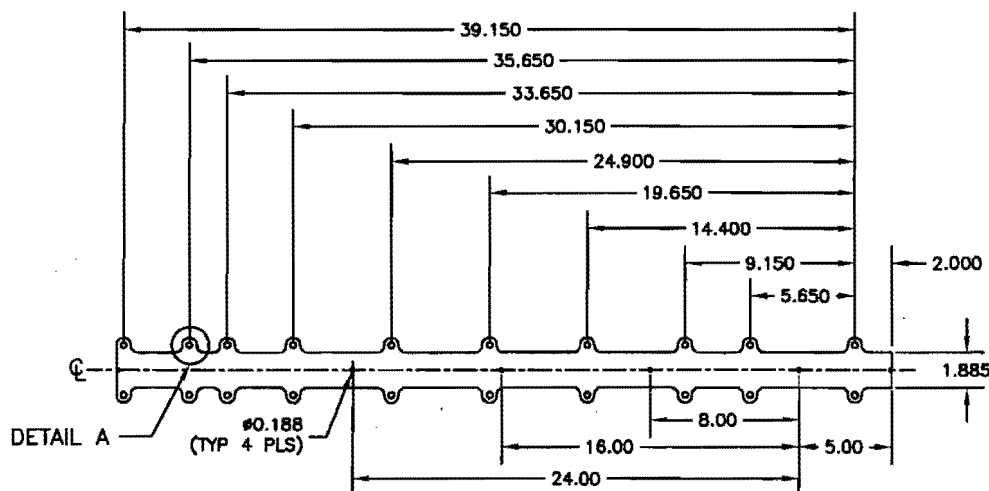
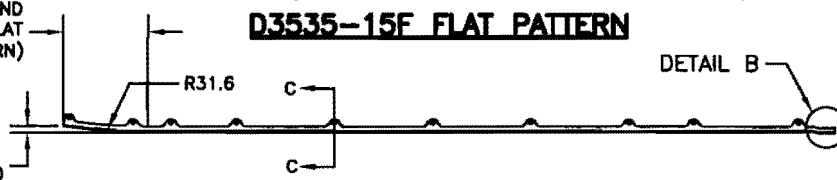
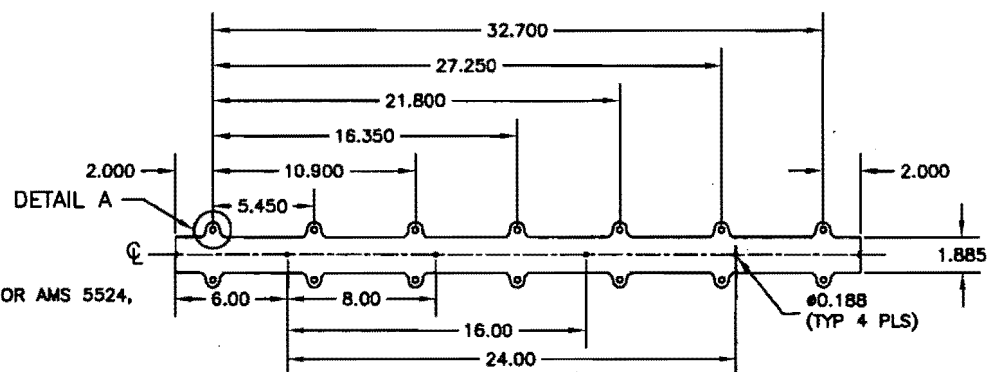
NOTE: Date & initial all entries

DART

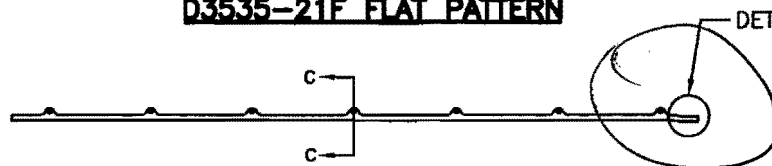
RELEASED

07.04.24

70380

4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15F FLAT PATTERN**0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE		D3535
07.04.17		WEARSHOE
		SHEET 2 OF 7
		SCALE
		1:10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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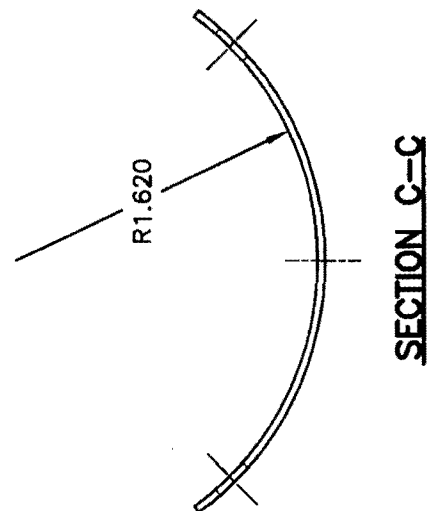
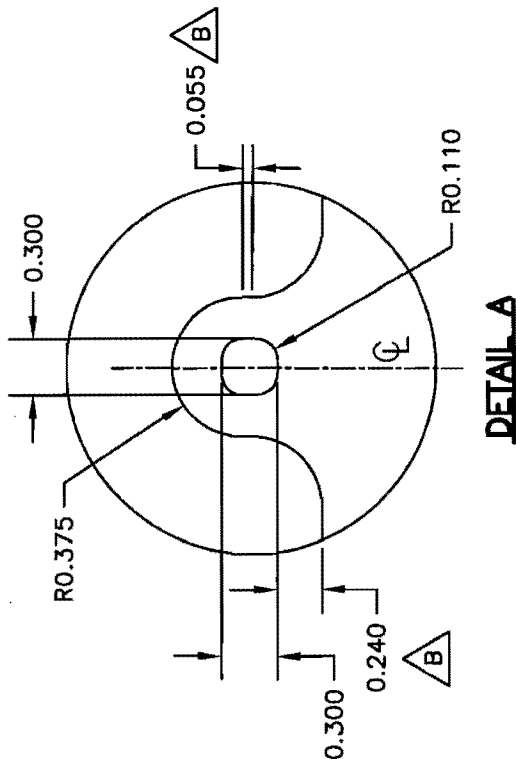
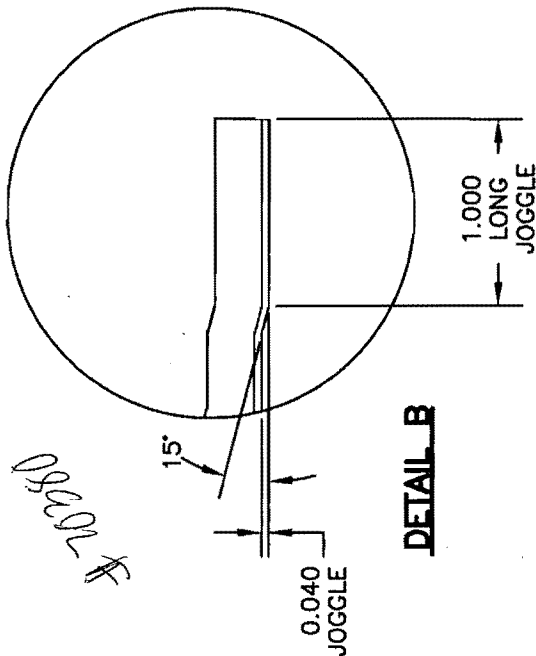
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DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

RELEASED
07.04.24



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Dart Aerospace Ltd

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